

Patent Claims

1. Wood fiberboard, in particular floor panel
5 comprising an HDF support board with a top side and an
underside, the top side having a decoration, preferably
a wood or tile decoration, characterized in that the
decoration is printed onto the top side of the support
board and is covered by at least one layer of a
10 transparent synthetic resin.

2. Wood fiberboard, according to Claim 1
characterized in that the decoration is printed on to
the underside of the support board.

15 3. Wood fiberboard, according to Claim 1 or 2,
characterized in that the decoration is covered by two
layers of a synthetic resin, the layer which is applied
directly to the decoration having corundum particles
20 for increasing the abrasion resistance.

4. Wood fiberboard, according to one or more of
Claims 1 to 3, characterized in that the top side has a
relief corresponding to the decoration.

25 5. Wood fiberboard, according to Claim 4
characterized in that the underside also has a relief
corresponding to the decoration.

30 6. Process for producing a wood fiberboard according
to Claim 1 or 2, characterized by the following steps:

a) a decoration, preferably a wood or tile
decoration, is printed onto one or two sides of
35 the board;

b) a screen roller is used to spread one or more
synthetic-resin layers, preferably melamine-resin
or urea-resin layers, on the side with the

decoration (top side) and the sides located opposite the latter (underside);

5 c) the synthetic-resin layers are pressed with the board in a known manner in a KT-press.

7. Process according to Claim 4, characterized in that the first synthetic-resin layer applied to the decoration is provided with corundum particles.

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8. Process according to Claim 6, characterized in that in the KT-press, a relief which corresponds to the decoration provided on the top side is stamped into the synthetic-resin layer.

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9. Process according to Claim 8, characterized in that a relief which corresponds to the decoration provided on the underside is also stamped.

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10. Process according to Claim 6, characterized in that the decoration is printed directly onto the top side and/or the underside of the support board.

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11. Process according to one of Claims 6 to 8 or 10, characterized in that floor panels are sawn from the wood fiberboard.